

Date: Thursday, 20/11/2008 3:35:29 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHAFT SLEEVE
Job Number : 43627	
Estimate Number : 11155	
P.O. Number :	Part Number : D32337
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D3233 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 37648	Material :
Written By :	Due Date : 21/12/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 08-11-21</u>	
Comment : Est. A 05.03.14 New issue KJ/JLM Est Rev:B Now on Doosan Lathe 08-04-01 JLM Verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1020TR1375W125	ROUND TUBE 1.375 x .125w



Comment: Qty.: 0.1860 f(s)/Unit Total : 1.8596 f(s)

1020-1025 Round Tube

Material: AISI 1020-1025 Seamless Round Tubing Cold Drawn per MIL-T-5066 or ASTM A513-00 MT1020

SRA or AMS 5075 or AMS 5077

(M1020TR1.375W.125)

Identify for D3233-7

Batch: 7101934

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: Doosan Lathe

1- Turn as per Folio FA735 Rev: N/A & Dwg D3233 Rev: B

2-Deburr per dwg D3233

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Dart Aerospace Ltd.

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:35:29 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHAFT SLEEVE

Job Number: 43627

Part Number: D32337

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PU 8/12/24 (11) ST 483 BANCAY

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08/12.24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

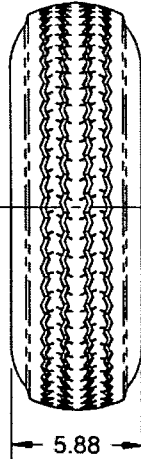
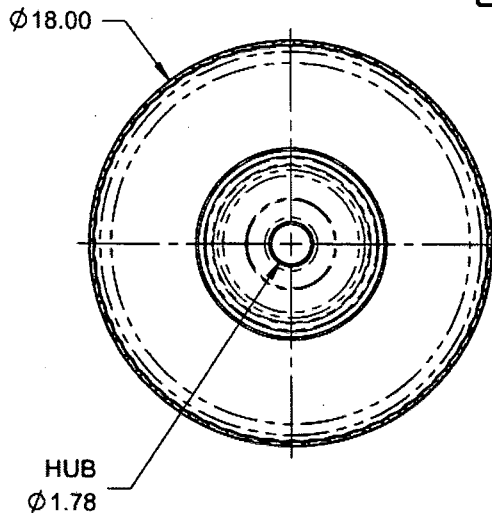
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

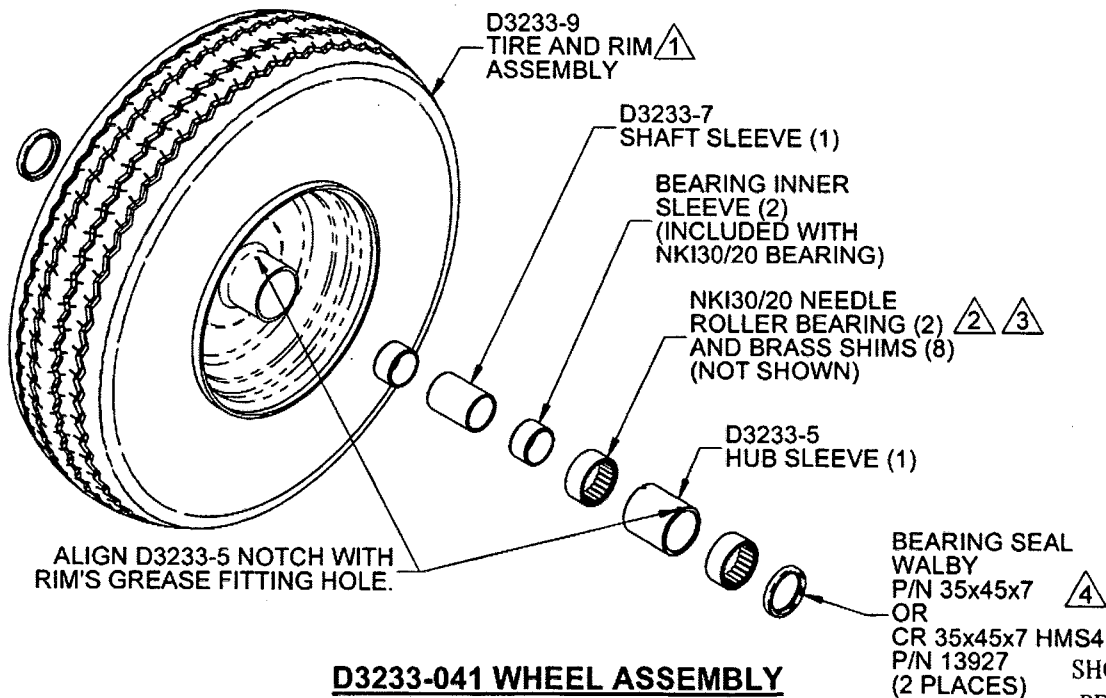
DART

DESIGN 3	DRAWN BY 3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	

**RELEASED**
05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

* MANUFACTURER'S RECOMENDATIONS
ARE 75 PSI FOR HIGH SPEED USE.

**D3233-041 WHEEL ASSEMBLY****NOTES:**

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE

WORK ORDER

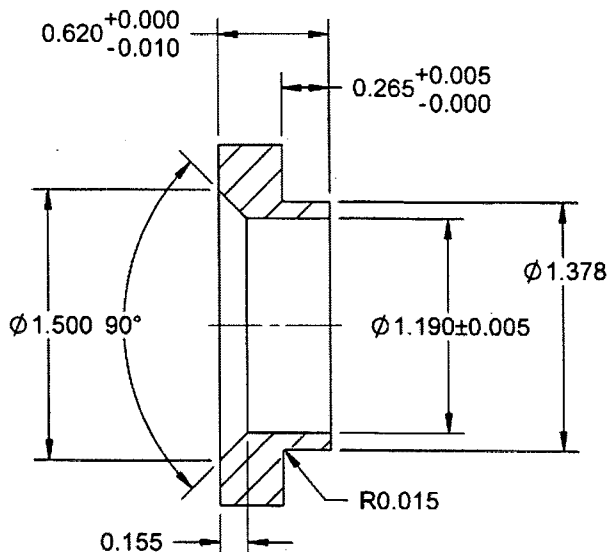
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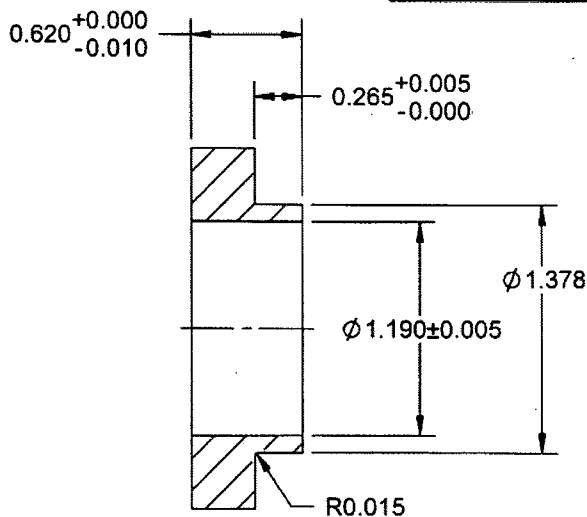
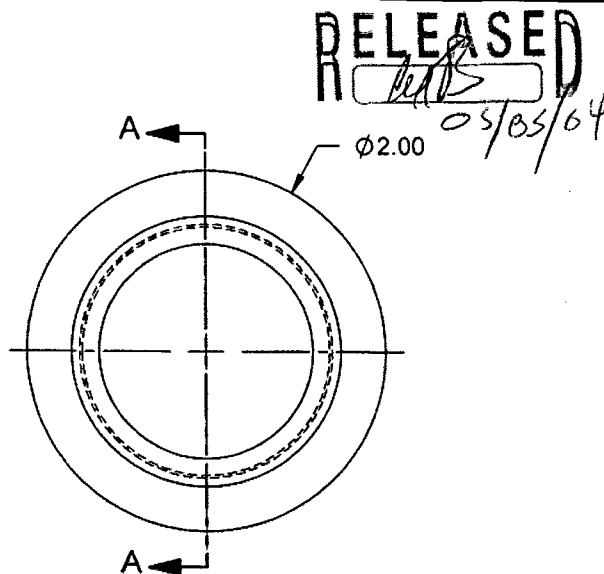


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 2 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1



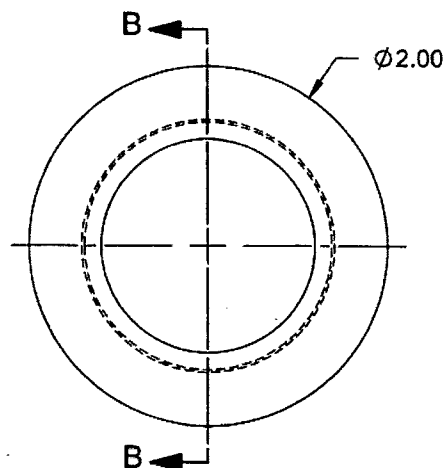
SECTION A-A

D3233-1 INSIDE WASHER



SECTION B-B

D3233-3 OUTSIDE WASHER



NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. *43622*

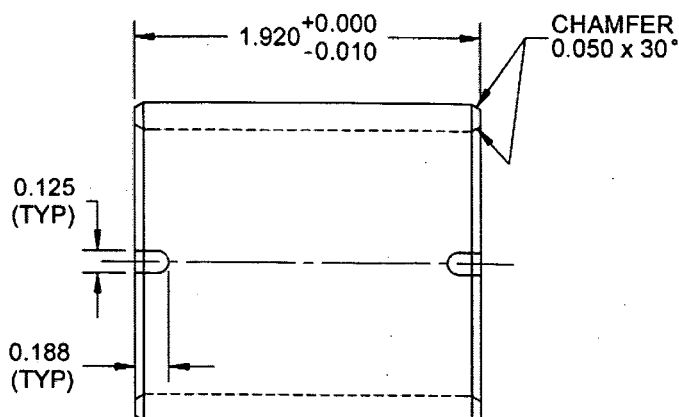
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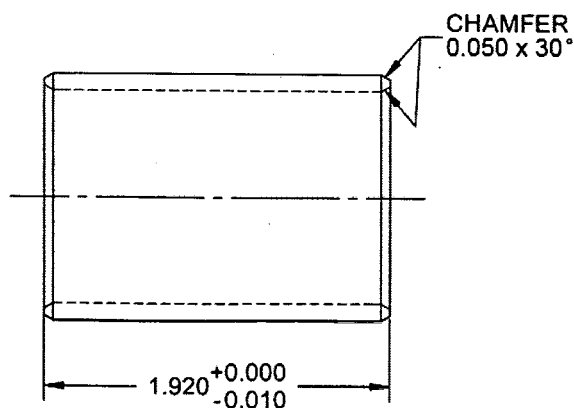
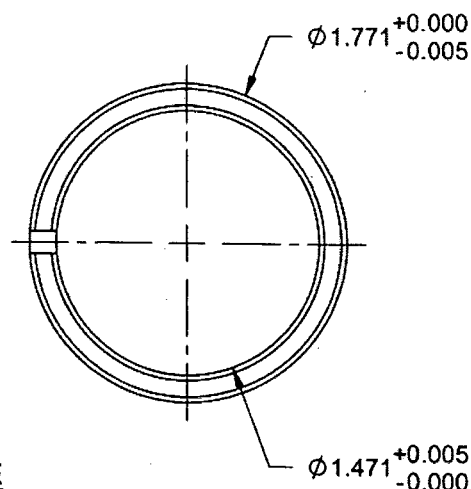


DESIGN 3	DRAWN BY 3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED R	APPROVED WBS	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

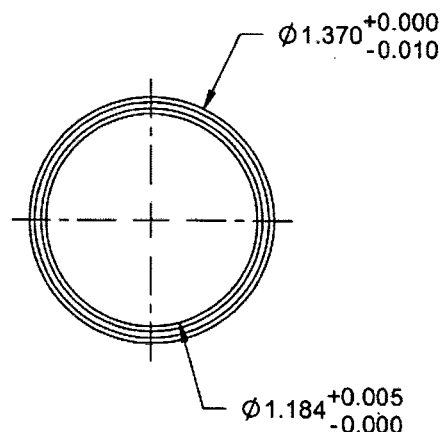
RELEASED
WBS
05/05/04



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE



NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00N CONTROLLED COPY
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS, SUBJECT TO AMENDMENT
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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